

-Work Order ID 128694

Thursday, January 22, 2015 11:15:26 AM

128694

Page 1

Item ID: D4811-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pin, Quick Release
Start Date: 1/22/2015 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 1/30/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: umf Date: 15-1-28 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4811	A

100

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 27199Possible Supplier: McMaster Carr
Supplier p/n: 98470A133

Material release note is required

0.00

0.00

CL 15/01/23 12

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure Material Release Note is attached

0.00

0.00

12x 8015-01-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Item ID: D4811-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pin, Quick Release
Start Date: 1/22/2015 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 1/30/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				(12)			DAS 38 9-89
120									
QC	Memo	0.00							

Quality Control

JAN 27 2015

130	Identify as per dwg & Stock Location: <u>St 130</u>	0.00				12			
130									
Packaging	Memo	0.00							
Packaging									

DAS
86
9-89

JAN 28 2015

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

15/1/29

15-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Thursday, January 22, 2015 11:15:25 AM

Page 1

Work Order ID: 128694

128694

Parent Item: D4811-1

D4811-1

Parent Item Name: Pin, Quick Release

Start Date: 1/22/2015

Required Date: 1/30/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 13.05.21 AS PER DWG REV.A VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
98470A133		Purchased		No		110	Each	0.0000	1	12			
98470A133									**				
Pin, Quick Release													

12x 8015-01-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

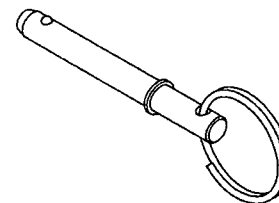
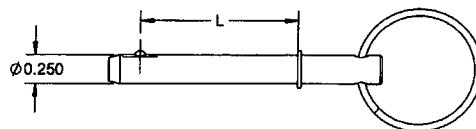
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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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SPECIFICATION CONTROL DRAWING



#128694

DART PART NUMBER	DESCRIPTION	POSSIBLE VENDOR	VENDOR PART NUMBER	L	MATERIAL
D4811-1	QUICK RELEASE PIN	MCMaster CARR	98470A133	1.347	18-8 SS

RELEASED
2013-05-16
MP

NOTES:

- 1) MATERIAL: PER TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 METHOD 6.7
- 7) WEIGHT: N/A

A	NEW ISSUE	DB	13.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	MP	D4811	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	QUICK RELEASE PIN	NTS
DATE	13.04.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

ACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER**Purchase Order ID PO27199****Purchase Order Date** 1/23/2015**PO Print Date** 1/23/2015**Page Number** 3 of 4**Order From :**

VU-MCM001

Ship To : DART AEROSPACE LTD

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name**Vendor Phone** 330 995 5500**Ship To Contact****Ship To Phone****Ship Via:** Purolator ground ppd**Ship Acct:****Buyer**

Chantal Lavoie

Customer POID**Customer Tax #**

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Line Total: \$13.32

7	59915K274	Rod End Bearing	1/27/2015 Yes 1/27/2015	10.00 ✓ Each	\$17.14	\$171.40
AS PER DWG D4777 REV. A B128451						

Line Total: \$171.40

8	92311A564	Set Screw	1/27/2015 Yes 1/27/2015	50.00 Each	\$0.24	\$11.87
AS PER DWG D3533 REV. B B128448						

Line Total: \$11.87

9	98470A133	Pin, Quick Release	1/27/2015 Yes 1/27/2015	12.00 ✓ Each	\$3.01	\$36.12
AS PER DWG D4811 REV. A B128694						

8015-01-27

Note:

1/23/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO27199

Order Placed By
Chantal Lavoie

McMaster-Carr Number
6331715-01

Page 1 of 1

01/23/2015

Line	Product	Ordered	Shipped
1	7494T86 Shop-Vac Vacuum Accessory, Plastic Reducer 2-1/2" Diameter X 1-1/4" Diameter Your Part Number: 71400-20	2 Each	2
2	9452K54 Oil-Resistant Buna-N Multipurpose O-Ring, 3/16 Fractional Width, Dash Number 334, Packs of 50 Your Part Number: 71500-30	1 Pack	1
3	8647A42 Mitutoyo Standard Electronic Caliper, 500-196-30, 0-6" (0-150MM) Range Your Part Number: 71500-65	1 Each	1
4	8647A32 Mitutoyo Standard Electronic Caliper, 500-193, 0-12" (0-300MM) Range Your Part Number: 71500-65	1 Each	1
5	6718K52 Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" NPTF Female, 1/4 Coupling Size	4 Each	4
6	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25	2 Packs	2
7	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	10 Each	10 ✓
8	92311A564 18-8 Stainless Steel Cup Point Set Screw, 1/4"-28 Thread, 1" Long, Packs of 50	1 Pack	1
9	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length	12 Each	12 ✓

SP 15-01-27

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 21385304
Purchase Order: PO27199
Release:
McMaster-Carr Number: 6331715-01

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Ultimate Destination:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Shipped: 23-Jan-2015 FOB: ORIGIN
Shipper's Export Declaration (SED):
NO EEI 30.36

Intermediate Consignee:

Bill To:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Tax Number:

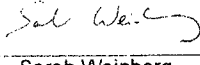
Forwarding Agent:

Billing
Attention:

Shipping
Attention:

Contact:

Line	Description	Qty & Unit	Unit Price	Extension
1	7494T86 Shop-Vac Vacuum Accessory, Plastic Reducer 2-1/2" Diameter X 1-1/4" Diameter 71400-20 Country of Origin: United States Schedule B #: 391740 ECCN #: EAR99 NLR	2 EA	\$7.59	\$15.18
2	9452K54 Oil-Resistant Buna-N Multipurpose O-Ring, 3/16 Fractional Width, Dash Number 334, Packs of 50 71500-30 Country of Origin: Peoples Republic of China Schedule B #: 401693 ECCN #: EAR99 NLR	1 PK	\$12.56	\$12.56
3	8647A42 Mitutoyo Standard Electronic Caliper, 500-196-30, 0-6" (0-150MM) Range 71500-65 Country of Origin: Japan Schedule B #: 901730 ECCN #: EAR99 NLR	1 EA	\$132.59	\$132.59
4	8647A32 Mitutoyo Standard Electronic Caliper, 500-193, 0-12" (0-300MM) Range 71500-65 Country of Origin: Japan Schedule B #: 901730 ECCN #: EAR99 NLR	1 EA	\$392.76	\$392.76
5	6718K52 Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" NPTF Female, 1/4 Coupling Size Country of Origin: United States Schedule B #: 848190 ECCN #: 2B999 NLR	4 EA	\$5.88	\$23.52
Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.				
These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.				

Shipping Weight (in kgs): 4	Number of Packages: 1	Invoice Amounts	Merchandise Amount: \$809.32
Package Dimensions: 15 X 46 X 20 CM = .014 CUBIC M			Canadian GST/HST: \$106.95
			Shipping Charges: \$13.40
			Total (In USD): \$929.67
		Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days	
Authorized Signature: 		Remit payment to:	(by wire transfer)
		(by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA	Bank of America Illinois 231 S LaSalle Chicago, IL 60697 ABA 071000039 Account 86666-02021 SWIFT BOFAUS3N
Date: 23-Jan-2015			
Name: Sarah Weinberg	Title: Operations Mgr.		

McMaster-Carr Supply Company
 200 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 21385304
 Purchase Order: PO27199
 Release:
 McMaster-Carr Number: 6331715-01

ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
6	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25 Country of Origin: Taiwan Schedule B #: 731822 ECCN #: EAR99 NLR	2 PK	\$6.66	\$13.32
7	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	10 EA	\$17.14	\$171.40
8	92311A564 18-8 Stainless Steel Cup Point Set Screw, 1/4"-28 Thread, 1" Long, Packs of 50 Country of Origin: Taiwan Schedule B #: 731815 ECCN #: EAR99 NLR	1 PK	\$11.87	\$11.87
9	98470A133 18-8 Stainless Steel Shoulder-Style Quick-Release Pin, Ring Grip, 1/4" Diameter, 1.3" Usable Length Country of Origin: United States Schedule B #: 731829 ECCN #: EAR99 NLR	12 EA	\$3.01	\$36.12
NOTE Tracking number(s) for this shipment: MFA004037822				

89501-27